

Date: Monday, 25/05/2009 12:48:55 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER  
 Job Number : 48198  
 Estimate Number : 13052  
 P.O. Number :  
 This Issue : 25/05/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D36704200  
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3670 REV A  
 Previous Run : 47122 Project Number : N/A  
 Material : A  
 Due Date : 01/06/2009 Qty: 100 Um: Each  
 Written By :  
 Checked & Approved By : JUD 09.05.25  
 Comment : Est Rev A new issue 07-10-30 DD verified by:  
 Est Rev:B Ecn 1056 Rev A dwg DD

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6T03125W058 ALUM TUBE .3125 x .058w



Comment: Qty.: 0.3675 f(s)/Unit Total : 36.7500 f(s)

Material:

(M6061T6T0.313W.058)

Batch: M111470

SA 09/05/25

16 A

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA711& DWG D3670

FOLIO REV: A

DWG REV: A

2-DEBURR AS REQUIRED

SA 09/05/25

(42)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 07/05/25

(42)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 09/05/25

(42)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BMC 47

SA 09/05/25 (42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 25/05/2009 12:48:55 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 48198

Part Number: D36704200

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/27 *mf*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*mf*  
09-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

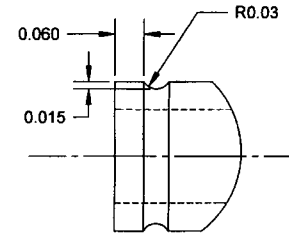
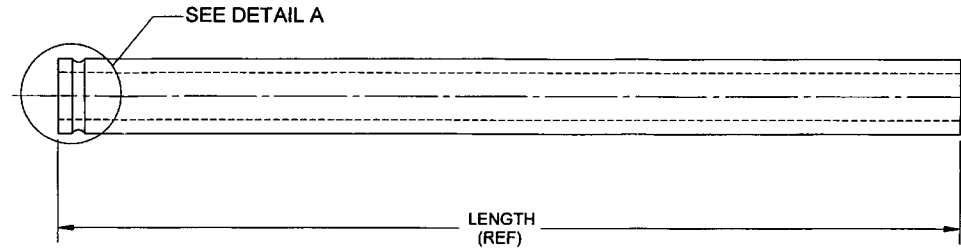
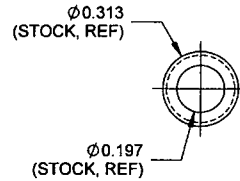
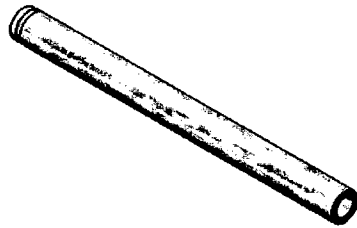
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# SPECIFICATION CONTROL DRAWING



DETAIL A  
(SCALE 4 : 1)

SPECIFICATION: D3670-XXXX SPACER  
LENGTH

WHERE XXXX IS LENGTH IN INCHES  
EG: 3.750" LONG SPACER: D3670-3750

RELEASED  
07.11.06

NO. 148  
WORK ORDER  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

- NOTES:
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T0.313W.058)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: N/A

A	NEW ISSUE	DC	07.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	h	DRAWING NO.	REV. A
MFG. APPR.	h	D3670	SHEET 1 OF 1
APPROVED	h	TITLE	SCALE
DE APPR.	h	SPACER	2:1
DATE	07.10.19	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	